

Work Order ID 56772

March 9, 2010 8:37:34 AM



Page 1

Item ID: D350-591-216

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short RH

Start Date: 3/09/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3168	Rev A
DSI 9472	A

100 DOCUMENT CONTROL 0.00



DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-216 CHG003

5 10/03/17

240 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00



Powdercoat

Memo

0.00

Powder Coating

PULLED FOR TRAIL INSTALLATION
B/N 53812
TOUCH UP AS NECESSARY

N/A

10-3-16

D.

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 08-89 TEL: 1-613-632-5200	
P/N	D350-591-216	CHG	CHG003		
DESC	Heli-Access Step RH Low	STC	SH92-6		
LOT	B53812	STC	SH967NE		
MODEL	AS350/355	STC			
MADE IN CANADA					

Work Order ID 56772

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Page 2

Item ID: D350-591-216

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop



Start Date: 3/09/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> MA 10/03/14

XL Ø
Assembly

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ADD MISSING HARDWARE TO KIT (SEE ATTACHED IIN) A/R

Rev 3/17 ①

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8.10.03/17

④

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Item ID: D350-591-216

Accept

Revision ID:

Item Name: Heli-Access-Step, Short RH

Start Date: 3/09/10 Start Qty: 1.00

Required Date: 3/10/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290



Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-591-216

USING NEW B/N

NEW LABELS REQ'D

Location:

PPP Rev: C

300



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

16/3/17 @

10-03-19

MF
10-3-18

Picklist Print

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Work Order ID: 56772

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A 02.10.17 New issue KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/09/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D350-591-216		Manufactured	No				Each	1.0000	1.0000			
Heli-Access-Step, Short RH												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

53812

1

1

110

Each

2,452.000 6.0000



53812

[Signature]

[Signature] 10/3/10 ①

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2452

102552

6

104248

6

110507

184

111827

280

113422

976

114108

1000

15924

0

1111827

MS21042L4



Nut

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Work Order ID: 56772

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A 02.10.17 New issue KJ
IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/09/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3-35A		Purchased	No			270	Each	177.0000	2.0000			



Bolt

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST353	177	
	106993	12	
	110467	1	
	112314	164	



Bolt

Purchased No

270 Each

422.0000

200

M112314

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST357	422	
	110382	422	

Purchased

No

270 Each

180.0000

4.0000

M110382



Bolt

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST357	180	
	113749	130	
	114108	50	

M113749

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Work Order ID: 56772

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A 02.10.17 New issue KJ
IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/09/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-16A		Purchased	No			270	Each	156.0000	4.0000			

Bolt

Warehouse Location

Main Warehouse

ST

156

112969

54

114129

100

18949

2

AN960JD10

Purchased

No

270

Each

0.0000

4.0000

Washer

AN960JD416

Purchased

No

270

Each

0.0000

12.0000

Washer

D2230-1

Manufactured

No

270

Each

103.0000

2.0000

Lug

Warehouse Location

Main Warehouse

ST

4

51761

4

Main Warehouse

ST476

99

54755

99

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Work Order ID: 56772

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A ☐ 02.10.17 ☐ New issue ☐ KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/09/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2230-3		Manufactured	No			270	Each	136.0000	2.0000			



Lug

USE OLD BATE
35470

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	7	
	50306	5	
	51568	2	

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST176	129	
	55310	129	

D2622-120C



Step Extrusion

Manufactured No

270 Each 134.2400 0.5000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	134.24	
	48612	3.12	
	52026	8.12	
	55214	123	

W/A

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Work Order ID: 56772

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments:

IPP Rev:A 02.10.17 New issue KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/09/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2732 030		Manufactured	No			270	f	57.3510	0.5000			
Rubber Extrusion												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	57.351	
38509	20.62	
43118	36.731	

270	f	240.7221	0.6000
-----	---	----------	--------

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST403	240.7220842	
50593	138.592084	
52563	102.13	

D2856-400 720 +1	
Abraison Strip	

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Work Order ID: 56772

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A ☐ 02.10.17 ☐ New issue ☐ KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/09/10

Required Date: 3/10/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3		Purchased	No			270	Each	2,357.000	2.0000			

Nut

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2351	
110844	35	
111274	27	
111668	52	
112314	285	
112385	232	
113523	20	
113537	700	
113644	1000	
Main Warehouse		
ST139	6	
111668	6	

1112385

Check 3/17

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

WDS6772

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Revision: G
Date: 08.10.06

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	09.08.05
CERT. NO.:	SH92-6
ISSUE NO.:	11

67056772

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Date: Wednesday, 3/17/10 9:52:52 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

REFERENCE ONLY

Job Number	: 34978	Customer	: Dart Helicopters Services
Estimate Number	: 11117	DWG Name	: SHORT STEP ASSEMBLY LOW SKID RH
Purchase Order #	:	Part Number	: D350591216
Complete Date	: 12/04/07 9:16:49 AM	DWG Number	: D3168 REV A
		Rev.	: A

DUE DATE	ORDERED	DELIVERED
10/30/07	3	3

2.0 D2622120C-Step Extrusion INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	D2622120C	1.000	\$27.30	Lot # 34016 Qty. 1
12/04/07	LACE01: Lacelle, Linda	D2622120C	0.500	\$13.36	Lot # 34016 Qty. 1

Subtotal: QTD: 1 CTD: 1 \$40.66

3.0 LARGE FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
10/17/07	EWER01: Ewers, Patrick	Run	3.000	0.20	\$3.86	0.20	4.59
10/17/07	EWER01: Ewers, Patrick	Run	3.000	0.19	\$3.66	0.19	4.36
10/18/07	EWER01: Ewers, Patrick	Run	3.000	0.58	\$11.18	0.58	13.30

Subtotal: QTD: 9 CTD: 0 0.97 \$40.95

5.0 D30671-End Plate INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	D30671	3.000	\$5.07	Lot # 35079 Qty. 3

Subtotal: QTD: 0 CTD: 3 \$5.07

6.0 D31691-Support INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	D31691	3.000	\$91.72	Lot # 25200 Qty. 3

Subtotal: QTD: 0 CTD: 3 \$91.72

7.0 LARGE FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
10/18/07	EWER01: Ewers, Patrick	Run	3.000	0.82	\$15.81	0.82	18.81
10/22/07	EWER01: Ewers, Patrick	Run	0.000	0.21	\$4.05	0.21	4.82
10/23/07	EWER01: Ewers, Patrick	Run	0.000	1.06	\$20.44	1.06	24.32
10/23/07	EWER01: Ewers, Patrick	Run	3.000	0.00	\$0.00	0.00	0.00

Subtotal: QTD: 6 CTD: 0 2.09 \$88.25

10.0 HAND FINISHING1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
10/23/07	DROU02: Drouin, Steven	Run	3.000	0.58	\$9.02	0.58	17.50

Subtotal: QTD: 3 CTD: 0 0.58 \$26.52

12.0 D30771-Step Leg INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	D30771	6.000	\$36.03	Lot # 26684 Qty. 6

Subtotal: QTD: 0 CTD: 6 \$36.03

Date: Wednesday, 3/17/10 9:52:52 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 34978	Customer	: Dart Helicopters Services
Estimate Number	: 11117	DWG Name	: SHORT STEP ASSEMBLY LOW SKID RH
Purchase Order #	:	Part Number	: D350591216
Complete Date	: 12/04/07 9:16:49 AM	DWG Number	: D3168 REV A
		Rev.	: A

13.0 D31701-Spacer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	D31701	6.000	\$179.25	Lot # 23578 Qty. 6
Subtotal: QTD: 0 CTD: 6 \$179.25					

14.0 MS20600AD4W4-Rivets INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	MS20600AD4W4	36.000	\$4.28	Lot # 105953 Qty. 36
Subtotal: QTD: 0 CTD: 36 \$4.28					

15.0 LARGE FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
11/26/07	MYRE01: Myre, Alexandre	Run	3.000	1.14	\$21.98	1.14	26.16	
Subtotal: QTD: 3 CTD: 0 1.14 \$48.14								

17.0 D30671-End Plate INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/27/07	EWER01: Ewers, Patrick	D30671	3.000	\$5.07	Lot # 35079 Qty. 3
Subtotal: QTD: 0 CTD: 3 \$5.07					

18.0 LARGE FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
11/27/07	EWER01: Ewers, Patrick	Run	3.000	0.60	\$11.57	1.11	25.47	
11/27/07	MYRE01: Myre, Alexandre	Run	3.000	0.39	\$7.52	0.39	8.95	
11/27/07	MYRE01: Myre, Alexandre	Run	0.000	0.50	\$9.64	0.50	11.47	
11/28/07	MYRE01: Myre, Alexandre	Run	3.000	0.05	\$0.96	0.10	2.30	
Subtotal: QTD: 9 CTD: 0 1.54 \$77.88								

21.0 HAND FINISHING1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
11/28/07	GREG01: Gregory, Marc	Run	3.000	0.08	\$1.07	0.16	4.17	
Subtotal: QTD: 3 CTD: 0 0.08 \$5.24								

22.0 POWDER COATING Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
11/28/07	GREG01: Gregory, Marc	Run	3.000	0.99	\$13.29	1.98	51.55	
Subtotal: QTD: 3 CTD: 0 0.99 \$64.84								

23.0 HAND FINISHING1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
11/29/07	GREG01: Gregory, Marc	Run	3.000	1.09	\$14.63	2.97	77.33	
Subtotal: QTD: 3 CTD: 0 1.09 \$91.96								

26.0 D22301-Lug INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	D22301	6.000	\$13.33	Lot # 32163 Qty. 6
Subtotal: QTD: 0 CTD: 6 \$13.33					

Date: Wednesday, 3/17/10 9:52:54 AM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 34978	Customer	: Dart Helicopters Services
Estimate Number	: 11117	DWG Name	: SHORT STEP ASSEMBLY LOW SKID RH
Purchase Order #	:	Part Number	: D350591216
Complete Date	: 12/04/07 9:16:49 AM	DWG Number	: D3168 REV A
		Rev.	: A

27.0 D22303-Lug INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	D22303	6.000	\$71.95	Lot # 35470 Qty. 6
Subtotal:		QTD:	0	CTD:	6
					\$71.95

28.0 D2732-Rubber Extrusion INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
12/04/07	LACE01: Lacelle, Linda	D2732	1.500	\$5.97	Lot # 34717 Qty. 2
Subtotal:		QTD:	2	CTD:	0
					\$5.97

29.0 D2856400-Abraison Strip INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	D2856400	1.800	\$7.62	Lot # 34642 Qty. 2
Subtotal:		QTD:	0	CTD:	2
					\$7.62

30.0 AN335A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	AN335A	6.000	\$5.08	Lot # 105408 Qty. 6
Subtotal:		QTD:	0	CTD:	6
					\$5.08

31.0 AN411A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	AN411A	18.000	\$3.73	Lot # 102280 Qty. 18
Subtotal:		QTD:	0	CTD:	18
					\$3.73

32.0 AN413A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	AN413A	12.000	\$3.18	Lot # 106043 Qty. 12
Subtotal:		QTD:	0	CTD:	12
					\$3.18

33.0 AN960JD10-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	AN960JD10	12.000	\$0.58	Lot # 105792 Qty. 12
Subtotal:		QTD:	0	CTD:	12
					\$0.58

34.0 AN960JD416-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	AN960JD416	36.000	\$1.02	Lot # 105906 Qty. 36
Subtotal:		QTD:	0	CTD:	36
					\$1.02

35.0 MS21042L3-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
11/29/07	QUIR01: Quirion, Sonia	MS21042L3	6.000	\$1.03	Lot # 102658 Qty. 6
Subtotal:		QTD:	0	CTD:	6
					\$1.03

Date: Wednesday, 3/17/10 9:52:55 AM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 34978	Customer	: Dart Helicopters Services
Estimate Number	: 11117	DWG Name	: SHORT STEP ASSEMBLY LOW SKID RH
Purchase Order #	:	Part Number	: D350591216
Complete Date	: 12/04/07 9:16:49 AM	DWG Number	: D3168 REV A
		Rev.	: A

36.0 MS21042L4-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
12/04/07	LACE01: Lacelle, Linda	MS21042L4	18.000	\$2.95	Lot # 105054 Qty. 18

Subtotal: QTD: 18 CTD: 0 \$2.95

		TIME	COST	
	Machine Time:	11.99	\$295.10	
	Labor:	8.48	\$148.68	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$478.52	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$922.30	

COST PER UNIT: \$307.43

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
DATE	09.08.05	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56772

March 9, 2010 8:37:34 AM



Page 1

Item ID: D350-591-216

Revision ID:

Item Name: Heli-Access-Step, Short RH

Start Date: 3/09/10 Start Qty: 1.00

Required Date: 3/10/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3168

Rev A

DSI 9472

A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-216 CHG003

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

PULLED FOR TRAIL INSTALLATION
B/N 53812
TOUCH UP AS NECESSARY

N/A

AL 10-3-16

D.

AL 10-3-17
①

REFERENCE ONLY

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-591-216	CHG	CHG003		
DESC.	Heli-Access Step RH Low	STC	SH92-6		
LOT	B53812	STC	SH967NE		
MODEL	AS350/355	STC			
MADE IN CANADA					
D2729-1					

